Work	Order ID	108811
4	1	

\*108811\*

Page 1

October-29-13 1	0:08:12 AM	1							·- ·			
Item ID: Revision ID:	D3925-1			Accept	*N900	040	100	)*	Setup S		*N:	S1*
Item Name:	Seatbelt Reel	Bracket							:	Stop	*N:	S2*
Start Date:	10/24/13	-Start Qty: 2.00	*2*		Cust Item I	D:						
Required Date:	10/29/13	Req'd Qty: 2.00	*2*		<b>Customer:</b>							
Reference:								_	- 4	C144		
Approvals:	Process Pl	an: MUS	Date: 13-10-3	Tooling:	D	ate:		J		Start	*N	R1*
	QC:		Date:	SPC (Y/N):	D	ate:	<u> </u>			Stop	*N	R2*
Sequence ID/ Work Center ID	)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp
Draw Nbr	Re	vision Nbr										
D3925	A											P
100		ELOW WATER IET		0.00								
*1,00*		FLOW WATER JET		0.00				2	<u> </u>	<u> </u>		Jm13-11-2
Waterjet FLOW-CNC Waterje	et	<b>Memo</b> 1-Cut as p Dwg Rev: Prog Rev: 2-Deburr i	<u>&amp;</u>	0.00								
110		QC2- Inspect parts off	machine FAI/FAIB	0.00								1
*110* QC Quality Control		Memo		0.00				_7_				Jm13-11-2
				D	AS							
*1:20		QC8- Inspect parts - se	econd check		27 <del>6</del> 9			J				1
QC Quality Control		Мето		0.00 Bln	192						Ţ	:

DQA:		Date	:									™ΩΔRT
QA Closed:		Date	! <b>:</b>		WORK ORDER NON-	-C(	ONFO	RMANCE / U		Vork Order uj	odate only	AEROSPACE
Work Orde	\r.				DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Work Orde  Part N  NCR N	No				Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	_	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
·							<u> </u>			<u></u>	oupplie! [	
Root Cause	Dat	te Step	Qty	Desc	ription of work order update or non-conformance	1	Initial nief Eng	i e	tion ription	Sign & Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved												
1						FAI	ULT CA	TEGORY				
Landii	Crack Crimp Cuffs Crush Heat Inspe Mark	e Not Conc s b/Kink/Ripp ing	le/Wave n Tube		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalig Mislabe Misread Off-set	on Incomplete/Ui ions Incomplete/U ned/off center iled	· ·	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
		/Twist in To			Fit/Function		1	Calibration Sequence				

October-29-13 10:08:12 AM

Item ID: Revision ID: Item Name:	D3925-1 Seatbelt Ree	l Bracket	mer et en met et er e <del>t e</del> e de de e	Accept	*	<b>1</b> 900	040	100	)* :	Setup S	Start Stop	*N:	S1*
Start Date: Required Date:	10/24/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*			Cust Item Customer:						IV.	, <b>7</b> /
Approvals:	Process P QC:	lan:		_ Tooling _ SPC (Y			Pate:		1		Start Stop	*N  *N	R1* R2*
Sequence ID/ Work Center II	)	Operation Description		Set I Run	Up/ Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp
*130 *130* Brake NC Brake NC		Form as per dwg NC BRAKE Memo		0.00			<sup>®</sup> AS 30 9 <del>*</del> 89		2				<u>13</u> u
140 *140* QC Quality Control		QC5- Inspect part comp	leteness to step on W/O	0.00	DAS 27 9-89 13/11/27				2	- <u>-</u>			
150 *150*		Chemical Conversion C	oat per QSI005 4.1	0.00					2	7	L,	. 13-/	2·Z
HandFinish Hand Finishing		Memo		0.00						<del></del>	= <i>\upsilon</i>	<u>, , , , , , , , , , , , , , , , , , , </u>	:

DQA:		Date:												TO AC
QA Closed:		Date:			WORK ORDER NON-	-C(	ONFO	RMANCE / UF	PDATE	W	ork Order up	ndate only		AEROSPACE
					DISPOSITION				4.6.4.4.67			•	Щ.	
Work Orde	er:				DISPOSITION				AGAINST	DE	PARTMENT,	/PROCESS		
					Rework			Skid-tube	Crosstube		]	Water Jet		Engineering
Part N	No				Scrap			Machining	Small Fab		Pro	d. Eng. Coor.		Quality
		•			Use-as-is		Therr	noforming	Finishing		Rec/Sto	re/Packaging		Other
NCR N	No	· ··-			Suspected Unapproved			Large Fab	Composite			Supplier	L	
Root				Desc	ription of work order update		Initial	Acti	on		Sign &		—	
Cause	Date	Step	Qty		or non-conformance	l	ief Eng	1			Date	   Verificatio	n	QC Inspector
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material								•						
Operator														
Offset/Setup														
Process														
Supplier														
Training								}						
Transport														
Unapproved														
		- <del> </del>				FA	ULT CA	TEGORY						
Landir	ng Gear				General		_		-		_			
	Bendir	g			Bend	L	Folio/F	Program			Outside Dim	ensions		Pressure/Forced
	Centre	Not Conce	ntric		BOM/Route		Grain				Over/Under	tolerance		Set-up
	Cracks				Broken/Damage/Defect		Hardwa	are			Part Incorre	ct		Temperature/Cure
	Crimp/	Kink/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Un	qualified		Part Lost/Mi	issing		Weld
	Cuffs				Contamination		Instruct	tions Incomplete/U	nclear		Part Moved			Wrong Stock Pulled
	Crushi	ng			Countersink		Misalig	gned/off center			Positioned V	Vrong		_
	Heat T				Cut Too Short		Mislabe	eled			Power Loss/	Surge		Other
	Inspec	tion Strip in	Tube	ļ	Drawing		Misread	d	,					
	Marks,	Chatter			Drill Holes		Off-set							
	_	g Sequence			Finish		Out of 0	Calibration						
l	Wave/	Twist in Tul	be	1	Fit/Function		Out of	Sequence						

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

	Vork Order ID 108811 ctober-29-13 10:08:12 AM em ID: D3925-1			*1	·	Page						
Item ID: Revision ID: Item Name:	D3925-1 Seatbelt Reel I	Bracket		Accept	*	N900	<b>040</b>	100	<b>)*</b> s	Setup Star Stop	ı Ņ.	S1* S2*
Start Date: Required Date: Reference:	10/24/13 10/29/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*			Cust Item I	D:					
Approvals:	Process Pla	n:	Date:	Tooling:		Da	ite:		F	Run Star Stoj	1/7	R1*
	QC:		Date:	SPC (Y/N)	):	Da	ıte:			Stop	′ *N'	R2*
Sequence ID/ Work Center II 160 *160* QC Quality Control	)	Operation Description QC7-Inspect Chemical Co	onversion Coat	Set Up/ Run Ho 0.00 0.00		Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*170* Packaging Packaging		Identify as per dwg & Sto	ck Location:	0.00					<u> 2x</u>		B-	DAS 26 989

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

\*1 **2**0\*

Quality Control

Am 13/12/03 MF 13-12-03

DQA:		_ Date:										<b>™</b> ∆APT
QA Closed:		Date:			WORK ORDER NON	-C(	ONFO	RMANCE / UPDATE	W	ork Order up	odate only	AEROSPACE
Work Orde	or.				DISPOSITION			AGAIN	IST DE	PARTMENT	/PROCESS	
WORK OTC		: -		_	Rework	1		Skid-tube Crosstu	he	7	Water Jet	Engineering
Part N	lo.				Scrap			Machining Small F	<b>—</b>	Pro	d. Eng. Coor.	Quality
					Use-as-is	1		noforming Finish	-	-1	re/Packaging	Other
NCR N	lo				Suspected Unapproved			Large Fab Compos	~ <del> </del> —	]	Supplier	
Root				Desci	ription of work order update		Initial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Design												
Doc/Data												
Equip/Tooling												
Handling/Pre												
Material												
Operator												
Offset/Setup												
Process												
Supplier												
Training												
Transport								ļ				
Unapproved				<u>.</u> .								
	<del></del>					FA	ULT CA	TEGORY				
Landir	ng Gear			_	General		•		_	_	_	_
	Bending				Bend		Folio/F	Program	L	Outside Dim	ensions	Pressure/Forced
	Centre I	Not Conce	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Cracks			<u> </u>	Broken/Damage/Defect		Hardwa	are		Part Incorred	ct _	Temperature/Cure
	Crimp/K	ink/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld
	Cuffs			_	Contamination		Instruct	tions Incomplete/Unclear		Part Moved	L	Wrong Stock Pulled
	Crushin	_			Countersink	_	1	gned/off center		Positioned V	Vrong	
	Heat Tre	eat			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
		on Strip in	Tube		Drawing		Misrea	d				
	Marks/0				Drill Holes		Off-set					
	Turning	Sequence	!		Finish		Out of	Calibration				
	Wave/T	wist in Tub	he		Fit/Function	1	Out of	Sequence				

Page 1/

Work Order ID:

108811

Parent Item:

D3925-1

Parent Item Name:

Seatbelt Reel Bracket

**Start Date:** 10/24/13

Required Date: 10/29/13

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP REV:A 13.07.04 PER DWG REV.A DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125 6061-T6 .125 Sheet		Purchased	No			100	sf	155.0000	0.09	0.1 <del>8947</del> 30	5 S	Jm	113-11-23
in the second se				Location		Loc Oty	La	o Codo					

 Location
 Loc Oty
 Loc Code

 MAT021
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 m127272
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DQA:		Date:			•							ADT
					WORK ORDER NON-	-CC	ONFO	RMANCE / U	PDATE			DARI
QA Closed:		Date:							V	Vork Order u	odate only	
Work Orde	er:				DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
				<del></del>	Rework	1		Skid-tube	Crosstube	٦	Water Jet	Engineering
Part N	No.				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is			noforming	Finishing	→	re/Packaging	Other
NCR I	No				Suspected Unapproved			Large Fab	Composite	1	Supplier	1   1
<del>-</del>	,				·							
Root				Desci	ription of work order update	I	nitial	Acti	ion	Sign &		
Cause	Date	Step	Qty	ļ	or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Design												
Doc/Data												
Equip/Tooling												
Handling/Pre					,							
Material -										!		
Operator												
Offset/Setup										:		
Process	$\vdash$											
Supplier	$\dashv$	·										
Training Transport	$\vdash$											
Unapproved												
опаррточеа	LL		<u> </u>	L		EAL	HTCA	     TEGORY		<u> </u>		
Landi	ng Gear				General	FA	JET CA	IEGORI				
	Bendin	g			Bend	$\Box$	Folio/F	Program	Г	Outside Dim	onsions .	Pressure/Forced
		Not Conce	ntric	-	BOM/Route	$\vdash$	Grain	TOBIAITI	-	Over/Under	<b>-</b>	Set-up
	Cracks				Broken/Damage/Defect	Н	Hardwa	ire	-	Part Incorre	<b>}</b>	Temperature/Cure
		Kink/Ripple	e/Wave		Burrs	H		ion Incomplete/Un	oualified	Part Lost/Mi	<b> </b>	Weld
	Cuffs	. , ,			Contamination	-	-	ions Incomplete/U	· —	Part Moved	-	Wrong Stock Pulled
•	Crushir	ng			Countersink	-		ned/off center		Positioned V	L Vrong	Toug Stock / unica
	Heat Ti				Cut Too Short		Mislabe		-	Power Loss/		Other
	Inspect	ion Strip in	Tube		Drawing	$\vdash$	Misread		<u>i</u>			2370
	Marks/	Chatter			Drill Holes	$\vdash$	Off-set			<del> </del>		
	Turning	g Sequence			Finish	$\vdash$		Calibration				
	Wave/	Twist in Tul	oe.		Fit/Function		Out of 9	Sequence				

DART AEROSPACE LTD	Work Order: 108811
Description: Scat Best Recs Brucket	Part Number: 139 25-1
Inspection Dwg: 03925 Rev: A	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.157"	+0.005-0.001	6.158"			V	J/mo1
0.209	to.005-0.001	0.210	_		V	
4.59"	11-0.030	4.590"			V	
3.∞"		3.000	_		V	
০. 78"		0.992"	-		V	
0.238"	4-0.000	0.235"	_		V	
2.25	4-0.030	2.266	_		V	
1.41	11	1.41"	•		V	
0.400	4-0.010"	0.400			J	
0.400		0.400	-		V	
3.20"	4-0.030"	3.204"			Ú	
5.95		5.953	•	_	V	
1.600"	t/-0:010°	1. Ce 000"	-		J	
0.30"	the "	0.320"	<b>-</b>		V	
0.533	_ (	0.538"	_		V	
0.35"	41-0:030"	0.385	_		<b>V</b>	
1.420"	41-0010	1.421"		i	V	
0.125		0.131			7	
	<del> </del>					
			·			
					:	
			DAS	L		1

Measured by: Jm

Date: 13-11-23

Audited by: 27
9-89

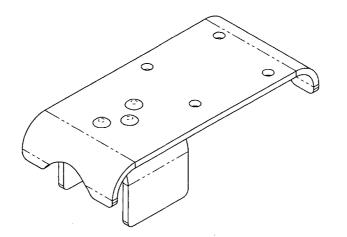
Preliminary Approval:

Date: 13 / J- 35

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

\$ 10.04.15

ITEM NO	QTY. -041	PART NUMBER		DESCRIPTION
1	Х	D3925-041	SI	EATBELT REEL BRACKET ASSY
9	1	D3925-1	BI	RACKET
10	1	D3925-3	BI	RACKET
21	3	MS20470AD5-8	RI	IVET



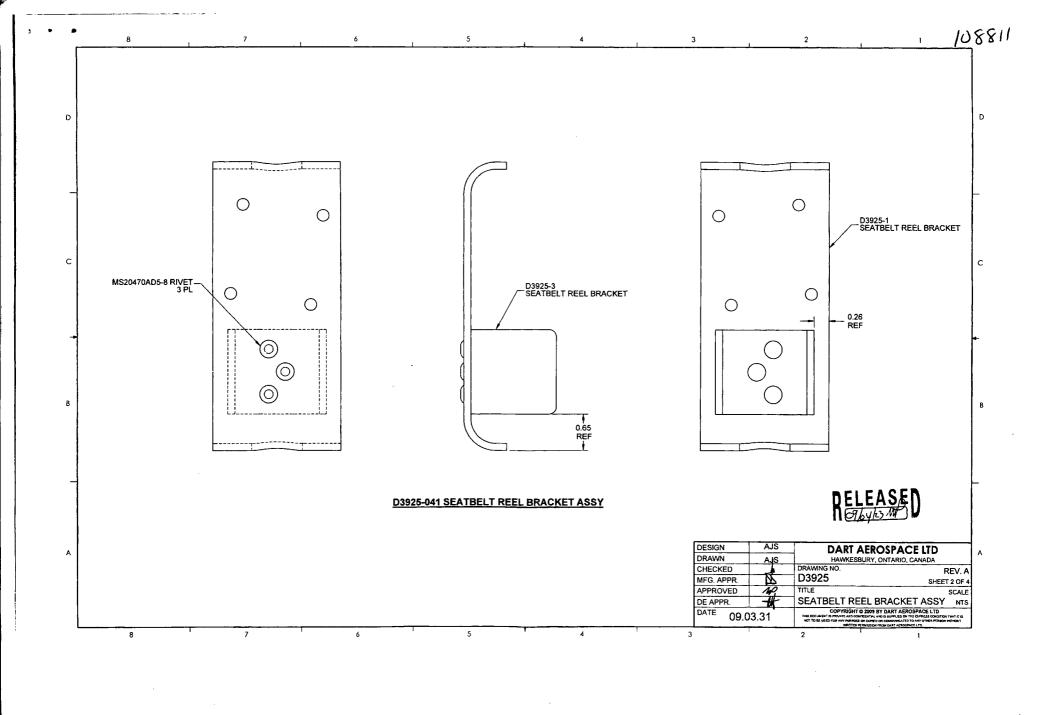
108811 MLJ

D

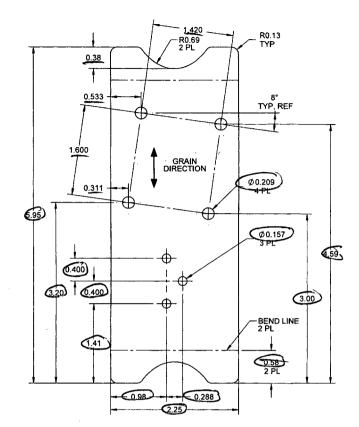
**D3925-041 SEATBELT REEL BRACKET ASSY** 

NOTES:
1) MATERIAL:
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3925-041" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.23 lbs

A NEW ISSUE 09.03.31 REV. DESCRIPTION BY DATE DESIGN AJS DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A D3925 MFG. APPR. SHEET 1 OF 4 APPROVED TITLE SCALE SEATBELT REEL BRACKET ASSY NTS DE APPR. COPYRIGHT © 2009 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRINTED AND CONTROLLING WISE SUPPLIED ON THE EXPENSION OF THE PRINTED AND THE PRINTED DATE 09.03.31



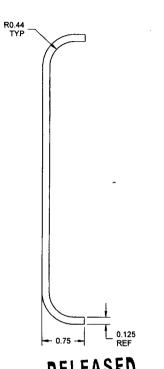
D



D3925-1F FLAT PATTERN

5.13

D3925-1 SEATBELT REEL BRACKET (MAKE FROM D3925-1F)



DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
DRAWN	AJS					
CHECKED	_	DRAWING NO. R	EV. A			
MFG. APPR.	77	D3925 SHEET	3 OF 4			
APPROVED	143	TITLE	CALE			
DE APPR.	44-	SEATBELT REEL BRACKET ASSY	NTS			
DATE 09.03.31		COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIMATE AND COMPEDITION, AND IS JUMPLED ON THE COMPSIS CONDITION THAT IT IS NOT TO BE UPON TO AM PURPOSE OR COPYRIGHT (SEED ON A TO PHILE PERSON WITHOUT)				

NOTES:
1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF DART SPEC M6061T6S.125
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.15 lbs

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